

Work Order ID 60860

Monday, July 26, 2010 11:30:06 AM



Page 1

Item ID: D3917-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

R

Date:

10-7-26

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3917

A

100

0.00



Hardinge

Memo

0.00

Hardinge CNC Lathe Small

TURN AS PER FOLIO FA876 & DWG
FOLIO REV: AA
DWG REV: A

SL 10/09/05



DEBURR

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

SL 10/09/05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 60860

Monday, July 26, 2010 11:30:07 AM



Page 2

Item ID: D3917-3

Accept



Setup Start



Revision ID:

Stop



Item Name: Washer

Start Date: 7/26/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 8/3/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				20	0		
130 Packaging Packaging	Identify as per dwg & Stock Location Memo	0.00 0.00							
140 QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

SP 10/09/05

C10/5/17 (20)

10/09/07
MP
10-9-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Monday, July 26, 2010 11:30:10 AM

Page 1

Work Order ID: 60860

Parent Item: D3917-3

Parent Item Name: Washer



Start Date: 7/26/2010

Required Date: 8/3/2010

Start Qty: 20.00

Required Qty: 20.00

Comments: Ipp Rev:A New Issue 09-12-02 JLM Verified by:DD
per dwg REV.A DD 10.02.22 verified by:EC IPP Rev:B as

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELNR0.750		Purchased	No			100	f	37.8600	0.02	0.421053			



Delrin Round Bar 0.75"



Location

Loc Qty

Loc Code

MAT

5.74

114595

5.74

MAT050

32.12

112418

0.12

115237

32

115472

43

JK 10/09/05

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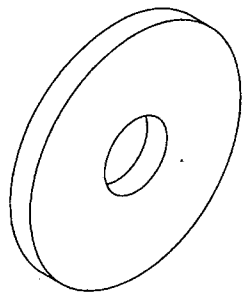
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

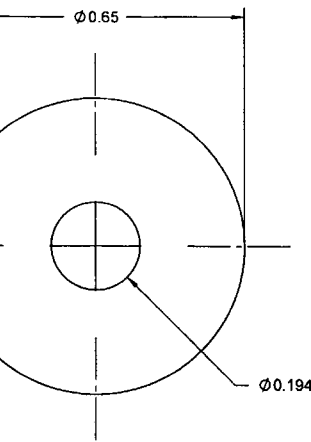
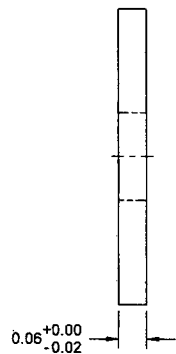
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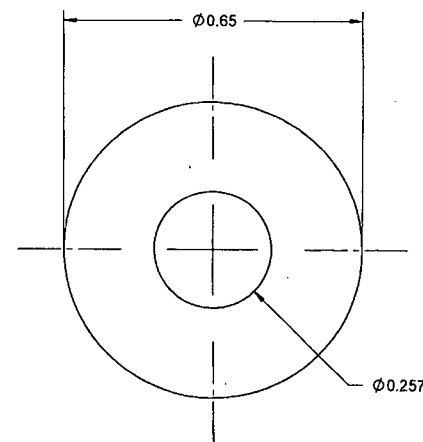
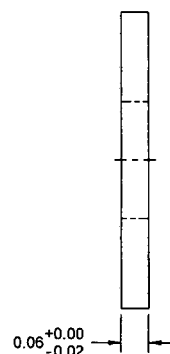
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 60860



ISO VIEW



D3917-1 WASHER



D3917-3 WASHER

RELEASED
2010-02-16

NOTES:

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL, COLOR BLACK
REF DART SPEC M-DELRIN-R
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: < 0.01 lbs

A		NEW ISSUE		JPH		10.01.29	
REV.		DESCRIPTION		BY		DATE	
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				REV. A	
DRAWN	AJS						
CHECKED	JS	DRAWING NO. D3917				SHEET 1 OF 1	
MFG. APPR.	JS	TITLE				SCALE	
APPROVED	JS	WASHER (350 BASKET)				NTS	
DE APPR.	JS						
DATE	10.01.29						

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